

NON-EUROCOPTER

Work Order ID 115247

115247

Page 1

March-20-14 8:04:50 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14 Start Qty: 4.00

*4*2
*4*2

Cust Item ID:

Required Date: 4/11/14 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3272 | Rev B |

100 Document Control
DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

DAS
31
9-89

2x

14-05-01

NON-EUROCOPTER

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 125127

3-Grind End Plate flush

4

1

14-03-26

PTO

DQA: AA Date: 14/05/10QA Closed: KH Date: 14/5/7

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

| | | | | | | |
|-----------------------------|---|---|------------------------------------|--|--------------------------------------|--|
| Work Order: <u>115243</u> | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | |
| Part No. <u>350-591-312</u> | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | |
| NCR No. <u>14-3820</u> | Scrap <input checked="" type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | |
| | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | |
| | Suspected Unapproved <input type="checkbox"/> | Large Fab <input checked="" type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|-----------|------|-----|--|------------------------|--|-------------|------------------------------|------------------------|
| Design | | | | Scrap 2 nd step the material is no good and lug is welded on the bad side of material Re. poor material / supplier | S 14/04/28 02092 | Scrap 2 nd step D2622-1204 D3272-1 \$50.70 | 14.4.14 | DAS 9 9-08 14.04.17 | S 14/04/28 02092 |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | X 14.4.14 | 110 | 2 | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | | |
|---|---|--|---|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Folio/Program | <input type="checkbox"/> Outside Dimensions |
| <input type="checkbox"/> Centre Not Concentric | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Grain | <input type="checkbox"/> Over/Under tolerance |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damage/Defect | <input type="checkbox"/> Hardware | <input type="checkbox"/> Part Incorrect |
| <input type="checkbox"/> Crimp/Kink/Ripple/Wave | <input type="checkbox"/> Burrs | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Part Lost/Missing |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Part Moved |
| <input type="checkbox"/> Crushing | <input type="checkbox"/> Countersink | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Positioned Wrong |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Power Loss/Surge |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Drawing | <input type="checkbox"/> Misread | <input checked="" type="checkbox"/> Other |
| <input type="checkbox"/> Marks/Chatter | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Off-set | <u>supplier / Poor material</u> |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Calibration | |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Out of Sequence | |

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Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14 Start Qty: 4.00

Required Date: 4/11/14 Req'd Qty: 4.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

②

14-04-17

DAS
9
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

②

14-04-17

DAS
9
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

2

7-6-14-22

②

Work Order ID 115247

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Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 4/11/14 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|---------------------------|
| 150 | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | 2 | 1 | | DAS 19 3 4-04-22 |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 180 | | 0.00 | | | | | | | |
| *180* | Large Fab | | | | | 2 | 14-04-24 | | DAS 9 9-89 |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1-Assemble Leg Assembly as per Dwg D3272. | | | | | | | | |
| | 2-Leave one rivet out until welding is complete. | | | | | | | | |
| | 3-Bevel Aft end for welding | | | | | | | | |
| | 4-Inspect for foreign object as per QSI 024 | | | | | | | | |
| | 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod <u>M25091</u> | | | | | | | | |
| | 6-Grind End Plate flush | | | | | | | | |
| | 7-Install last rivet as per Dwg. | | | | | | | | |

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Page 4

Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14

Start Qty: 4.00

4

Required Date: 4/11/14

Req'd Qty: 4.00

4

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

DAS

27

9-89

190

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.00

Hand Finishing

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Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14 Start Qty: 4.00 ***4***

Required Date: 4/11/14 Req'd Qty: 4.00 ***4***

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|----------------|------------------|-----------------------------|
| 220 | White Gloss(Ref 4.3 5.1) per OSI005 4.3-Alum | 0.00 | | | | | | | |
| *220* | <i>M128007</i> | | | | | <i>2</i> | <i>14-4-29</i> | | <i>DAS 34 8-89</i> |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | START TIME: <i>9:35</i> | | | | | | | | |
| | OVEN TEMPERATURE: <i>320°</i> | | | | | | | | |
| | FINISH TIME: <i>10:05</i> | | | | | | | | |
| 230 | Wing Walk as per dwg QSI005 4.4 Batch | 0.00 | | | | | | | |
| *230* | <i>M128003</i> | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | <i>X2R+1 c/ Al 14/04/29</i> |
| Hand Finishing | | | | | | | | | |
| 240 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *240* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

68-6 27 DAS
68-6 27 DAS

APR 30 2014

Work Order ID 115247

March-20-14 8:04:50 AM

115247

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Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/11/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

DAS
32
9-89

14-04-29

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

DAS
31
9-89

2

14-05-01

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: 08-083DAS
03
9-89

2

MAY 01 2014

Work Order ID 115247

March-20-14 8:04:50 AM

115247

Page 7

Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/11/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 14-05-05

14-05-02

Picklist Print

March-20-14 8:04:47 AM

Page 1

Work Order ID: 115247

115247

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

DSI 9410-011

Manufactured No

Each 3.0000

DSI 9410-011

Amends Installations Of D350-591-311/312 Steps

DAS
31
9-09

Location

Loc Qty

Loc Code

FG123

3

112717

1

113447

2

Each

0.0000

1

4

D3272-1

Manufactured No

D3272-1

Step

D3067-1

Manufactured No

D3067-1

End Plate

Location

Loc Qty

Loc Code

WA003

131

101785

67

102686

64

Each

117.0000

2

8

D3219-1

Manufactured No

D3219-1

Plate

Location

Loc Qty

Loc Code

WA003

117

112125

117

DAS
06
9-09

115899

14.03.25

14.03.25

14.03.25

8

Picklist Print

March-20-14 8:04:48 AM

Page 2

Work Order ID: 115247

115247

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

D3066-1 Manufactured No

180 Each 43.0000 2 8

D3066-1

Spacer

④ 14.04.23 PD

Location

Loc Qty

Loc Code

WA003

43

5115186 → 4

106302

23

112583

20

MS20600-AD4W4 Purchased No

180 Each 3,331.000 16 64

MS20600-AD4W4

Rivets

③ 14.04.23 PD

Location

Loc Qty

Loc Code

ST311

1831

125577

1831

32

ST554

1500

M128429

1500

D3065-041 Manufactured No

180 Each 19.0000 1 4

D3065-041

Step Leg Assembly

② 14.04.23 PD

Location

Loc Qty

Loc Code

WA003

19

5112315 → 2

102830

6

108770

10

109447

3

D3067-1 Manufactured No

180 Each 131.0000 1 4

D3067-1

End Plate

② 14.04.23 PD

Location

Loc Qty

Loc Code

WA003

131

5115340 → 2

101785

67

102686

64

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Shop Packet Print

Page 2

Picklist Print

March-20-14 8:04:48 AM

Page 3

Work Order ID: 115247

115247

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

AN3-35A

Purchased

No

250

Each

67.0000

2

84

AN3-35A

Boil

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

10

122800

10

ST352

57

m127460

1

m128300

56

**

128634

DAS

33

9-89

D3235-1

Manufactured

No

250

Each

199.0000

2

84

D3235-1

Mounting Lug

DAS

31

9-89

Location

Loc Qty

Loc Code

ST470

199

102818

13

105939

106

108670

80

**

105939

DAS

33

9-89

D3278-041

Manufactured

No

250

Each

94.0000

1

42

D3278-041

Support Assembly

DAS

31

9-89

Location

Loc Qty

Loc Code

ST469

90

111885

50

114169

40

ST470

4

102349

1

109406

3

**

1111885
114169

DAS

33

9-89

March-20-14 8:04:48 AM

Shop Packet Print

Page 3

Picklist Print

March-20-14 8:04:48 AM

Page 4

Work Order ID: 115247

115247

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

250

Each

3,591.000

16

64 32

NAS1149D0463J

WASHER

**

128591

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST294

290

M127693

290

ST510a

3301

M127813

301

M127904

3000

NAS1149D0563J

Purchased

No

250

Each

4,915.000

4

16 8

NAS1149D0563J

Washer

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

GA

201

m125807

201

ST510a

4714

m126319

2714

m128257

2000

126319

AN5-36A

Purchased

No

250

Each

130.0000

2

84

AN5-36A

Bolt

**

128850

DAS

33

9-89

14-04-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST338

1

M126105

1

st503

129

M127410

29

M127460

100

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Shop Packet Print

Page 4

Picklist Print

March-20-14 8:04:49 AM

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Work Order ID: 115247

115247

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

D2618

Manufactured No

250

Each

239.0000

8

DAS
33
9-89

D2618
Bushing

DAS
31
9-89

Location

Loc Qty

Loc Code

ST013

239

103863

17

108671

96

97780

126

108671

D2230-3

Manufactured No

250

Each

366.0000

16

DAS
33
9-89

D2230-3
Mounting Lug

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST469

359

105940

18

108668

138

109344

202

111818

1

109344

D2856-400

Manufactured No

250

f

339.6100

5

DAS
33
9-89

D2856-400
Abrasion Strip 4" Wide (Per Foot)

2 per K.T

DAS
31
9-89

Location

Loc Qty

Loc Code

ST403

339.61

109578

123.61

112524

216

109578

cut (2) D2856-400-720 as per dwg

Picklist Print

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Work Order ID: 115247

115247

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

250

Each

3,822.000

2

84

**

DAS

33

9-89

MS21042L3

Nut

DAS

31

9-89

Location

Loc Qty

Loc Code

ST314

2867

M127410

1826

M127831

41

M128401

1000

ST506

955

123900

955

1,844.000

8

2216

**

DAS

33

9-89

AN4-13A

Purchased

No

250

Each

AN4-13A

Bolt

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

14

m125709

14

ST515

1810

m127432

36

m127817

774

m128403

1000

786.0000

2

84

**

DAS

33

9-89

MS21042L5

Purchased

No

250

Each

MS21042L5

Nut

DAS

31

9-89

Location

Loc Qty

Loc Code

GA

5

117611

5

ST315

281

m127304

281

ST509

500

m127813

500

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Shop Packet Print

Picklist Print

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March-20-14 8:04:49 AM

Work Order ID: 115247

115247

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 3/20/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

250

Each

4,986.000

8

32-16

**

DAS
33
9-89

DAS
33
9-89

MS21042L4
Locknut

DAS
31
9-89

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST314 | 44 | |
| m126015 | 12 | |
| m126275 | 32 | |
| ST509 | 4931 | |
| m127255 | 159 | |
| m127813 | 1772 | |
| m128300 | 3000 | |
| ST518 | 11 | |
| m127376 | 11 | |

128300

NAS1149D0363J

Purchased

No

250

Each

6,212.000

4

16 8

**

DAS
33
9-89

DAS
33
9-89

NAS1149D0363J
Washer

DAS
31
9-89

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| GA | 23 | |
| 124392 | 23 | |
| ST510a | 6189 | |
| m126319 | 193 | |
| m127813 | 996 | |
| m128429 | 5000 | |

128429

March-20-14 8:04:49 AM

Shop Packet Print

Page 7

DART

| | | | |
|----------------------|----------------------|--|------------------------|
| DESIGN <i>qp</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>H</i> | DRAWING NO. D3272 | REV. B SHEET 1 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE NTS |
| A | 04.03.01 | NEW ISSUE | |
| B | 07.05.18 | D3272-1 WAS D2622-120 | |

RELEASED*07.06.04*

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|-------------------------------|
| X | | D3272-041 | STEP ASSEMBLY, HIGH LONG (LH) |
| | X | D3272-042 | STEP ASSEMBLY, HIGH LONG (RH) |
| | | | |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| -1 | 1 | D3272-1 | STEP |
| | | | |
| 16 | 16 | MS20600AD4W4 | RIVET |
| | | | |

GENERAL NOTES:

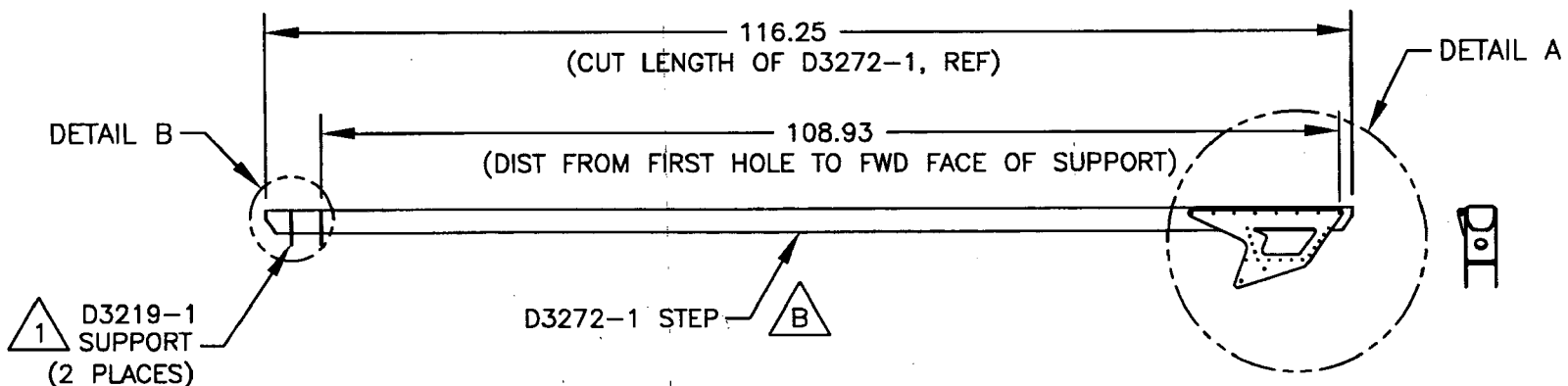
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*W/D
2x2x7***Copyright © 2004 by DART AEROSPACE LTD**

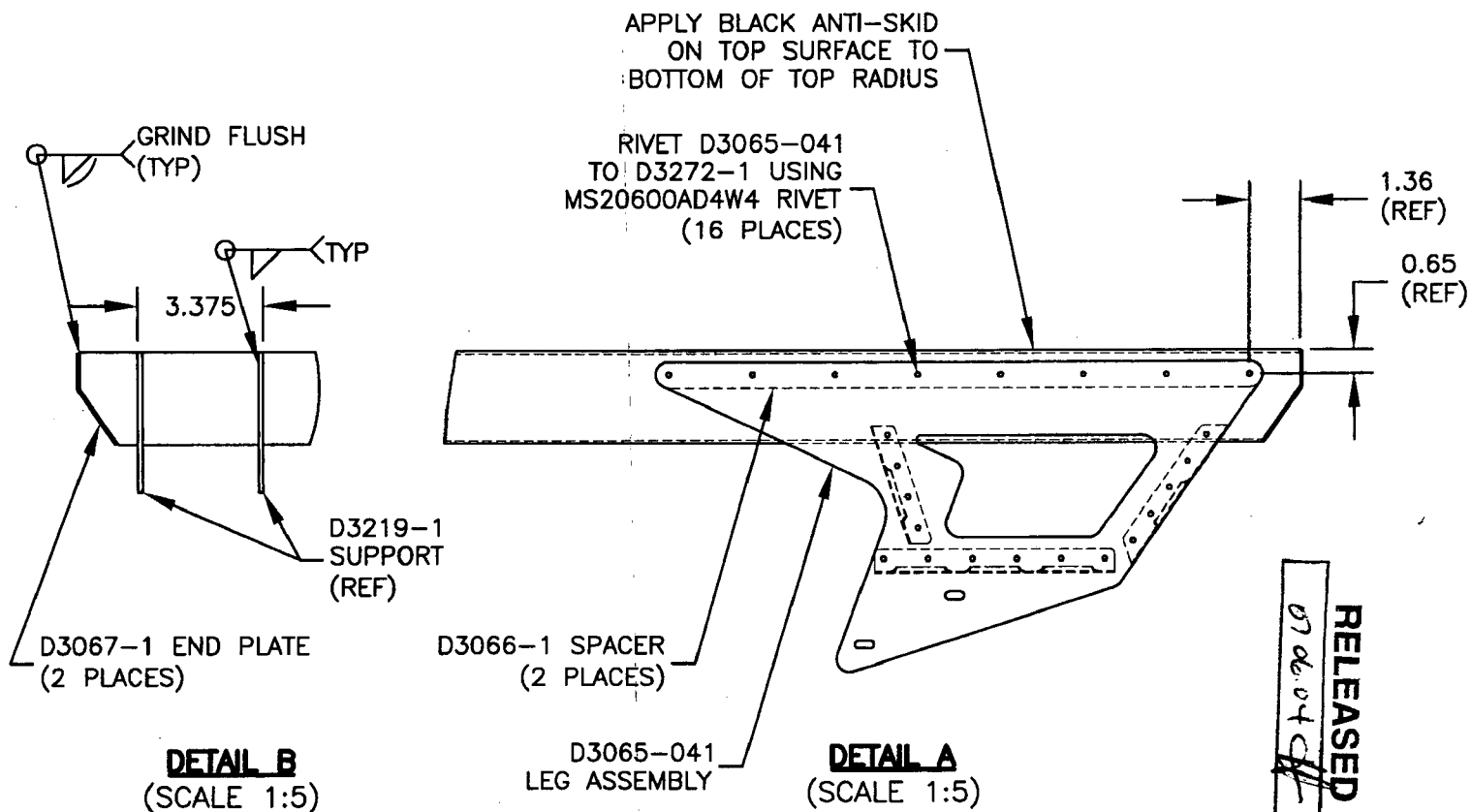
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| | | | |
|----------|-------------|-----------------------------|--------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | REV. B |
| CHECKED | APPROVED | HAWKESBURY, ONTARIO, CANADA | |
| DATE | DRAWING NO. | SHEET 2 OF 3 | SCALE |
| 07.05.18 | D3272 | STEP ASSEMBLY, HI LONG | 1:20 |



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

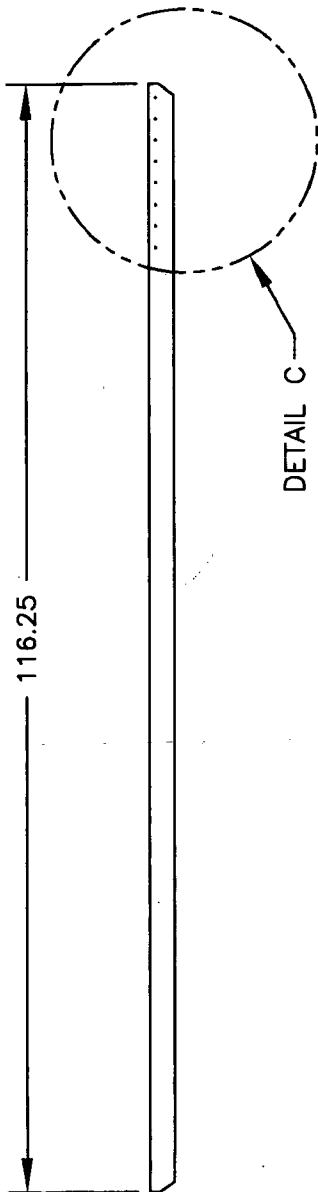




| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>JB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3272 | REV. B SHEET 3 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE 1:20 |

RELEASED

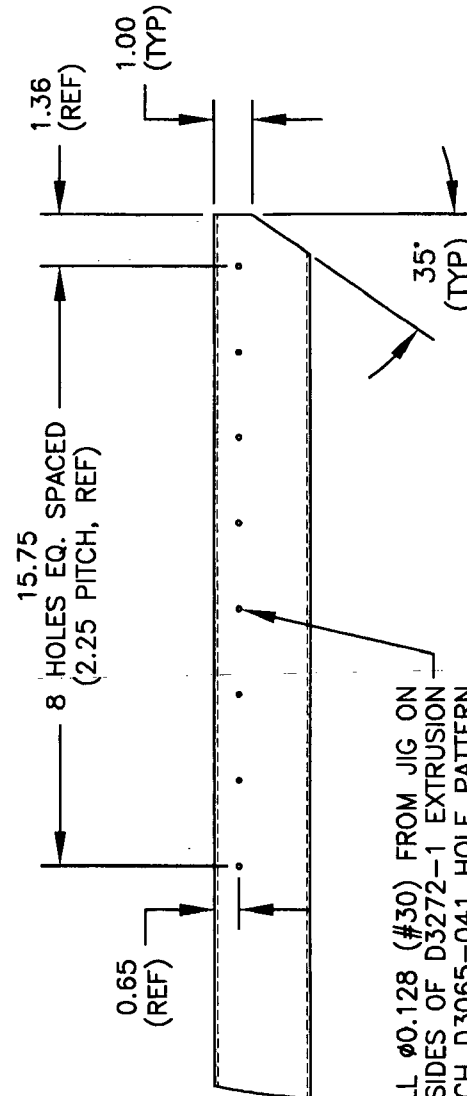
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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14-05-01

| Qty -211 | Qty -212 | Qty -213 | Qty -214 | Qty -215 | Qty -216 | Qty -311 | Qty -312 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|---|
| X | | | | | | | | D350-591-211 | Heli-Access-Step™ , Long Step – High Skid, LH |
| | X | | | | | | | D350-591-212 | Heli-Access-Step™ , Long Step – High Skid, RH |
| | | X | | | | | | D350-591-213 | Heli-Access-Step™ , Short Step – High Skid, LH |
| | | | X | | | | | D350-591-214 | Heli-Access-Step™ , Short Step – High Skid, RH |
| | | | | X | | | | D350-591-215 | Heli-Access-Step™ , Short Step – Low Skid, LH |
| | | | | | X | | | D350-591-216 | Heli-Access-Step™ , Short Step – Low Skid, RH |
| | | | | | | X | | D350-591-311 | Heli-Access-Step™ , Long Step – High Skid, LH |
| | | | | | | | X | D350-591-312 | Heli-Access-Step™ , Long Step – High Skid, RH |
| 1 | | | | | | | | D3070-041 | STEP ASSEMBLY (HIGH-LONG, LH) |
| | 1 | | | | | | | D3070-042 | STEP ASSEMBLY (HIGH-LONG, RH) |
| | | 1 | | | | | | D3078-041 | STEP ASSEMBLY (HIGH-SHORT, LH) |
| | | | 1 | | | | | D3078-042 | STEP ASSEMBLY (HIGH-SHORT, RH) |
| | | | | 1 | | | | D3168-041 | STEP ASSEMBLY (LOW-SHORT, LH) |
| | | | | | 1 | | | D3168-042 | STEP ASSEMBLY (LOW-SHORT, RH) |
| | | | | | | 1 | | D3272-041 | STEP ASSEMBLY (HIGH-LONG, LH) |
| | | | | | | | 1 | D3272-042 | STEP ASSEMBLY (HIGH-LONG, RH) |
| 4 | 4 | | | | | | | D2182B035 | RUBBER CUSHION |
| | | 2 | 2 | 2 | 2 | | | D2230-1 | MOUNTING LUG |
| | | 2 | 2 | 2 | 2 | 4 | | D2230-3 | MOUNTING LUG |
| 8 | 8 | | | | | | | D2274 | RADIUS BLOCK |
| | | | | | | 2 | | D2618 | BUSHING |
| 4 | 4 | 4 | 4 | 4 | 4 | | | D2732-030 | CUSHION |
| 2 | 2 | 1 | 1 | 1 | 1 | 2 | | D2856-400,720 | ABRASION STRIP |
| 2 | 2 | | | | | | | D3064-1 | CLAMP |
| 1 | 1 | | | | | | | D3079-041 | SUPPORT ASSEMBLY |
| 4 | 4 | | | | | | | D3080-1 | CLAMP |
| | | | | | | 2 | 2 | D3235-1 | MOUNTING LUG |
| | | | | | | 1 | 1 | D3278-041,2 | SUPPORT ASSEMBLY |
| 2 | 2 | 2 | 2 | 2 | 2 | 2 | 2 | AN3-35A | BOLT |
| 10 | 10 | 2 | 2 | 2 | 2 | | | AN4-11A | BOLT |
| | | 4 | 4 | 4 | 4 | 8 | 8 | AN4-13A | BOLT |
| | | | | | | 2 | 2 | AN5-36A | BOLT |
| 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | AN960JD10 | WASHER |
| 20 | 20 | 12 | 12 | 12 | 12 | 16 | 16 | AN960JD416 | WASHER |
| | | | | | | 4 | 4 | AN960JD516 | WASHER |
| 2 | 2 | 2 | 2 | 2 | 2 | 2 | 2 | MS21042L3 | NUT |
| 10 | 10 | 6 | 6 | 6 | 6 | 8 | 8 | MS21042L4 | NUT |
| | | | | | | 2 | 2 | MS21042L5 | NUT |
| | | | | | | 1 | 1 | DSI 9410-011 | STEP MODIFICATION KIT |

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.